

Work Order ID 133696

Tuesday, June 16, 2015 10:36:54 AM

133696

Page 1

Item ID: PB67-43001-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Square Tube

Stop ***NS2***

Start Date: 6/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: JUN 16 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100

100

Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

1- cut to length as per dwg

2- make a chamfer on both ends of tube as per dwg

3- deburr

bx DA 15/7/8

110

110

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

6

DAS
38
9-89

JUL 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Tuesday, June 16, 2015 10:36:54 AM

133696

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Square Tube

Stop *NS2*

Start Date: 6/16/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 6/16/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 Identify as per dwg & Stock Location: Mezz 2

0.00

120

Packaging

Memo

0.00

Packaging

68-6
6
DAS

6 J.A.

~~5497-61-770~~

JUL 13 2015

130	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

0.00

130

OC

Memo

0.00

Quality Control

ML5

JUL 14 2015

ML5

JUL 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, June 16, 2015 10:36:57 AM

Page 1

Work Order ID: 133696

133696

Parent Item: PB67-43001-141

PB67-43001-141

Parent Item Name: Square Tube

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 5		Purchased		No		100	f	290.5830	0.9219	6			

M6061T6TS1 000W 125

6061T6 SQ TUBE 1.00 x 1.00 x .125w

OK 15/7/8

Location

Loc Qty

Loc Code

MAT028

290.583

m128034

210.5

m128248

80.083

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

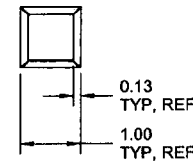
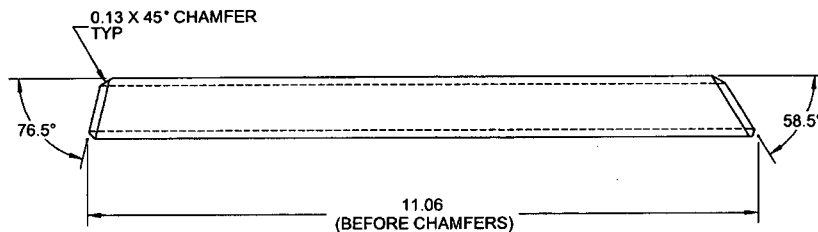
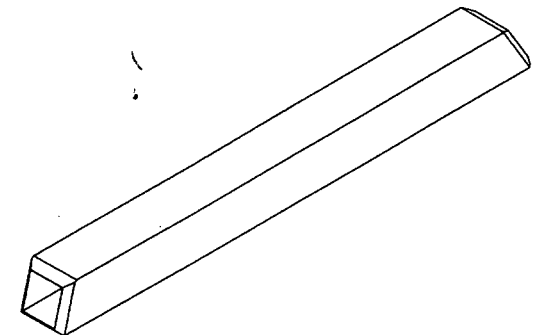
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
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		OTHER : ☐			

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 133696.MJS

150616



B67-43001-141 SQUARE TUBE

RELEASED
 2009-09-24
 MB

- NOTES:
 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF. DART SPEC. M6061T6TS1.000W0.125
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.45 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 22 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RAW		DART AEROSPACE LTD	
DRAWN	13		HAWKESBURY, ONTARIO, CANADA	
CHECKED	13		DRAWING NO.	REV. C
MFG. APPR.	13		B67-43001-141	SHEET 1 OF 1
APPROVED	13		TITLE	SCALE
DE APPR.	N/A		SQUARE TUBE	NTS
DATE	09.02.19		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	